

Work Order ID 86583

July-05-12 1:13:51 PM

86583

Page 1

Item ID: **D2989-041** Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 7/05/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/27/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: C2 Date: 12/07/05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989								
	2- tack weld mesh on basket as per dwg D2989 using DT9445 jig								
	****cut cutouts with zip cut as per dwg D3832****								
	3- remove from jig and weld lable plate as per dwg D2989								
	A/R ER316 S.S. Rod Batch: <u>M122130</u>								
	*** PLEASE NOTE ***								
	IF MAKING -043A								
	ENSURE I X D3836-041 HAS NO BUSHING AND HAS HOLES PER								
	DSI9473								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

Pl 12.12.17

D4 23 18 12.12.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00	<i>DAS</i> <i>15</i> <i>2-89</i>	<i>DAS</i> <i>09</i> <i>2-89</i>		<u>1</u>			
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00				<u>1</u>	<i>MB</i>	<u>12-12-18</u>	

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref.4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes prior to powder coating								
	2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989								
	1ST COAT:								
	START TIME: 1:00								
	OVEN TEMPERATURE: 400°F								
	FINISH TIME: 1:30								
	***** 2nd coat if necessary*****								
	2ND COAT:								
	START TIME: 2:00								
	OVEN TEMPERATURE: 400°F								
	FINISH TIME: 2:30								
131	Wing Walk as per dwg QSI005 4.4 Batch 120589	0.00							
131									
HandFinish	Memo	0.00							
Hand Finishing	Mask lid prior to spray paint black and wing walk as per dwg								
	A/R Spray paint black batch: 119945								

WU 23383

IX ~~φ~~ MK 12/12/18

1 ~~φ~~ 12/12-19

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
141	Identify as per dwg & Stock Location 358607 043	0.00							
141									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MF
12-12-27

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Picklist Print

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Work Order ID: 86583
 Parent Item: D2989-041
 Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12
 Start Qty: 1.00

Required Date: 7/27/12
 Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:I 08-12-02 revD as per dwg DD verified by:EC IPP rev:M 10 09.14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	8.0000	2	2		24 8-09/12.12.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				83907		8							
D2506 Label Plate		Manufactured	No			100	Each	12.0000	1	1		24 8-09/12.12.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		12							
				79197		1							
				82705		11							
D2512-7 Rib		Manufactured	No			100	Each	8.0000	1	1		24 8-09/12.12.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				53444		0							
				77522		4							
				81048		4							

Dart Aerospace Ltd

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Work Order ID: 86583

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 7/27/12

Start Qty: 1.00

Required Qty: 1.00

D2581
Mounting Bracket

Manufactured No

100 Each 61.0000 2 2

DAS 24 8-8 12/12/12
392871 → ②

Location	Loc Qty	Loc Code
WA	39	
82506	2	
83230	3	
85436	10	
85452	24	
WA005	22	
70766	2	
81253	1	
82897	19	

D2989-13
Rib

Manufactured No

100 Each 4.0000 2 2

DAS 24 8-8 12/12/12
386971 → ②

Location	Loc Qty	Loc Code
WA	4	
84604	4	

D2989-19
Rib

Manufactured No

100 Each 10.0000 2 2

DAS 24 8-8 12/12/12
387650 → ②

Location	Loc Qty	Loc Code
WA	10	
77519	4	
84603	6	

D3832-3
Mesh (Lid)

Manufactured No

100 Each 1.0000 1 1

DAS 24 8-8 12/12/12
386576 → ①

Location	Loc Qty	Loc Code
WA035	1	
77520	1	

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 86583

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 7/27/12

Start Qty: 1.00

Required Qty: 1.00

D3833-3
Mesh (Lid End)

Manufactured No

100 Each 13.0000 2 2

DAS 24 12.12.12
B87412 → ①
B87413 → ①

Location	Loc Qty	Loc Code
WA	4	
81142	4	
WA035	9	
67460	9	

D3836-041
Rib Assembly (Basket Lid, LH)

Manufactured No

100 Each 4.0000 1 1

DAS 24 12.12.12
B89446 → ①

Location	Loc Qty	Loc Code
WA	4	
77515	4	

D3836-042
Rib Assembly (Basket Lid, RH)

Manufactured No

100 Each 4.0000 1 1

DAS 24 12.12.12
B89245 → ①

Location	Loc Qty	Loc Code
WA005	4	
77514	4	

D3852-041
Rib Assembly

Manufactured No

100 Each 6.0000 1 1

DAS 24 12.12.12
B87906 → ①

Location	Loc Qty	Loc Code
WA005	6	
77512	2	
86042	2	
86154	2	

D3852-042
Rib Assembly

Manufactured No

100 Each 5.0000 1 1

DAS 24 12.12.12
B87905 → ①

Location	Loc Qty	Loc Code
WA	1	
77513	1	
WA005	4	
66089	1	
77513	1	
86043	2	

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Shop Packet Print

Page 3

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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

△

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

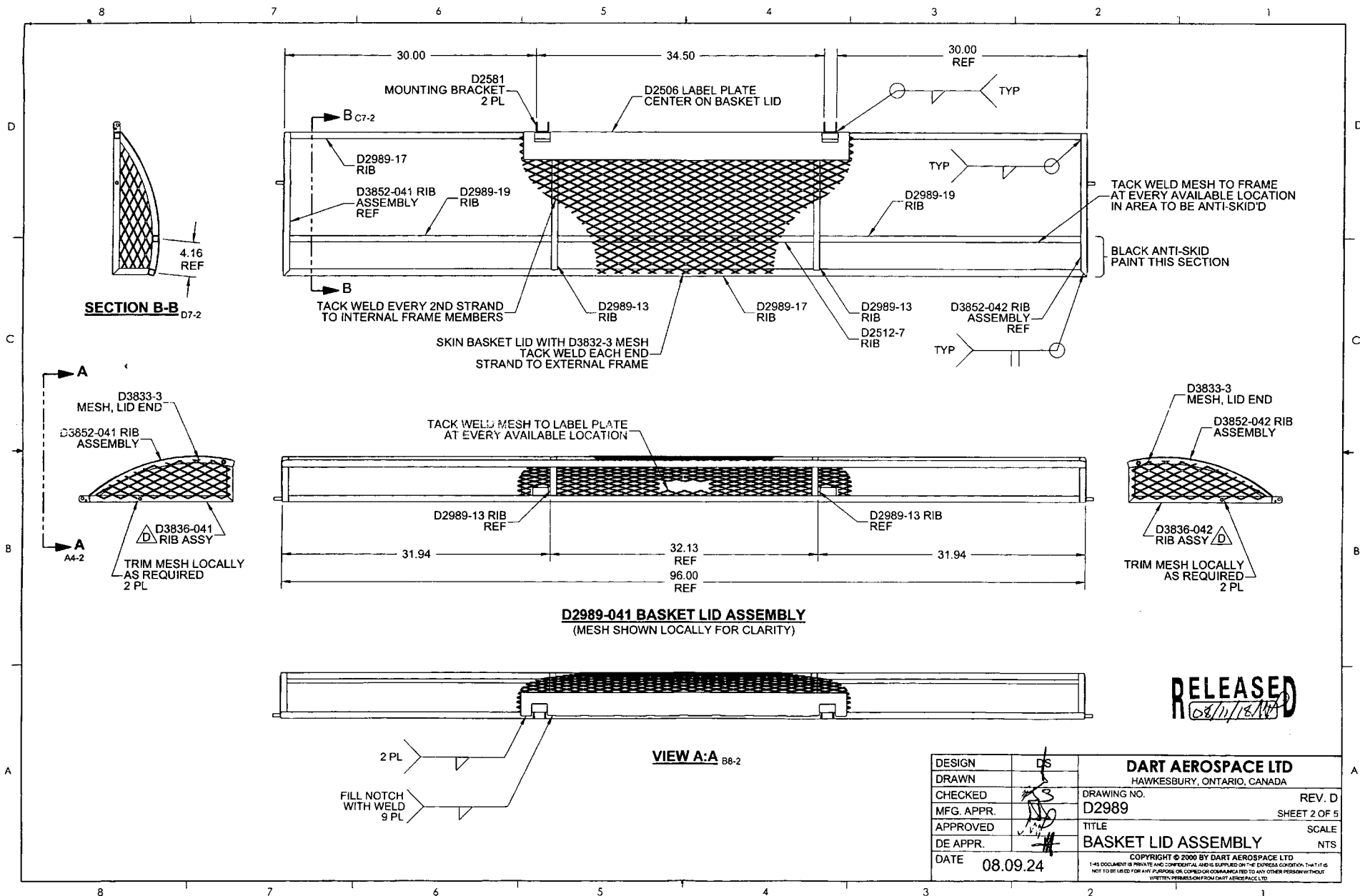
RELEASED
08/11/18

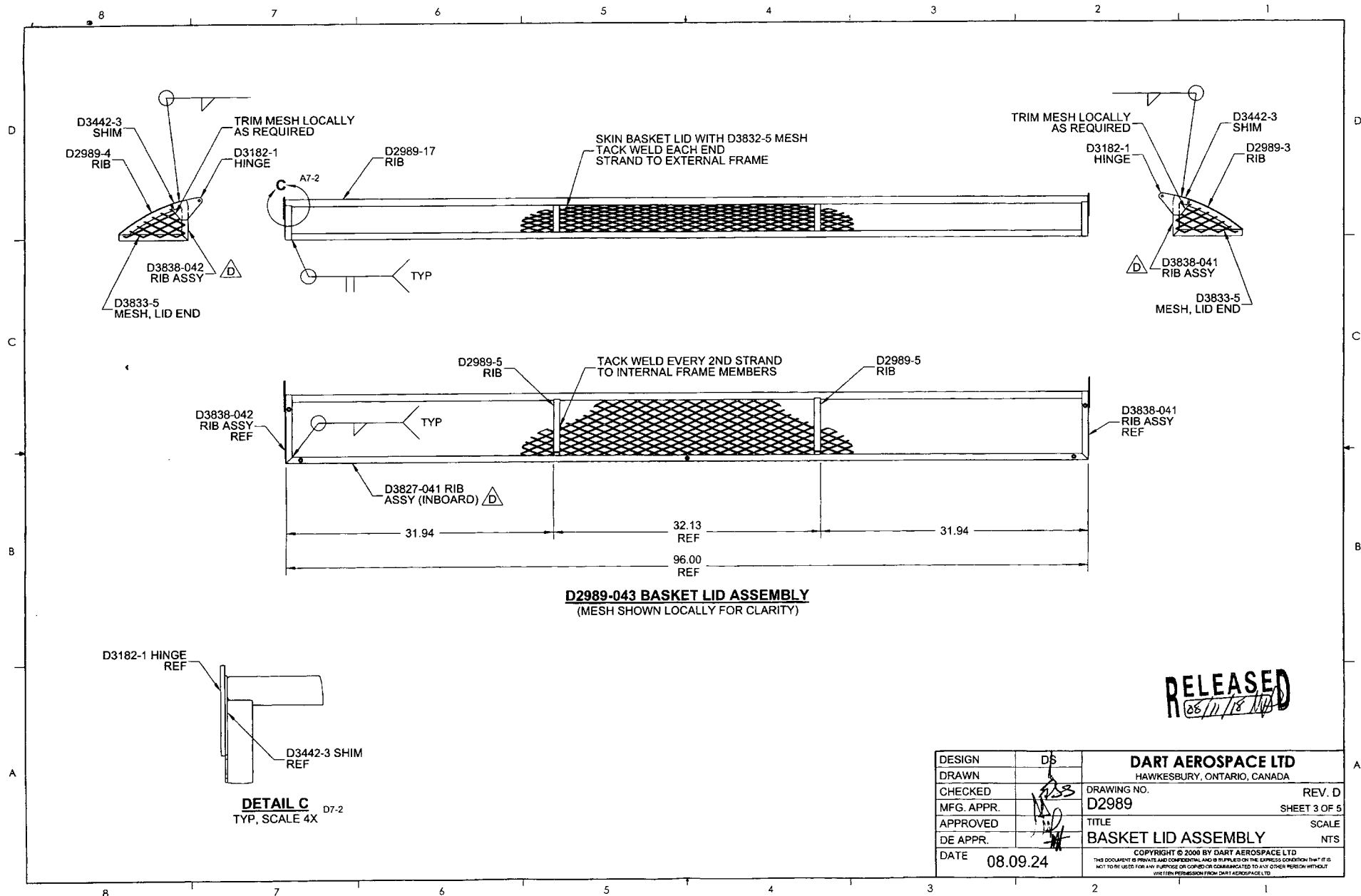
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-8/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	CS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		

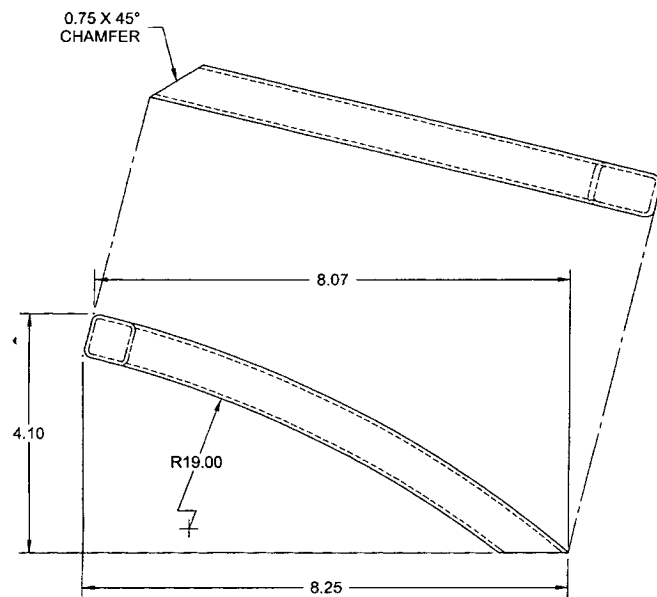
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

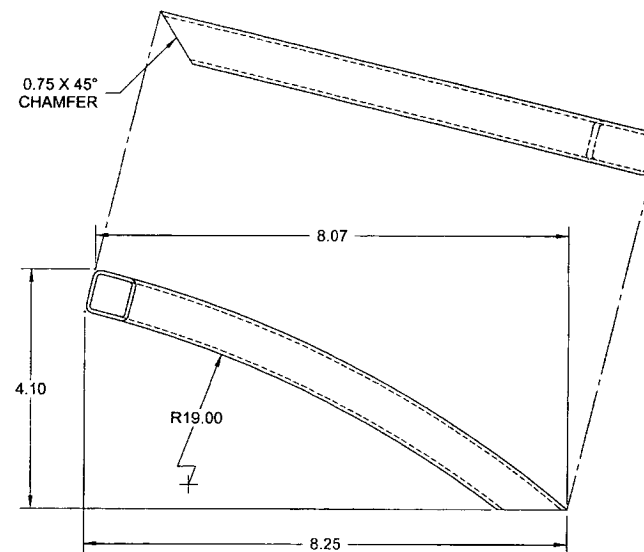
CL12107/05
W10: 86383







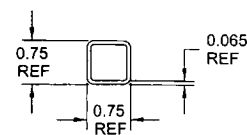
D2989-3 RIB



D2989-4 RIB

NOTES:

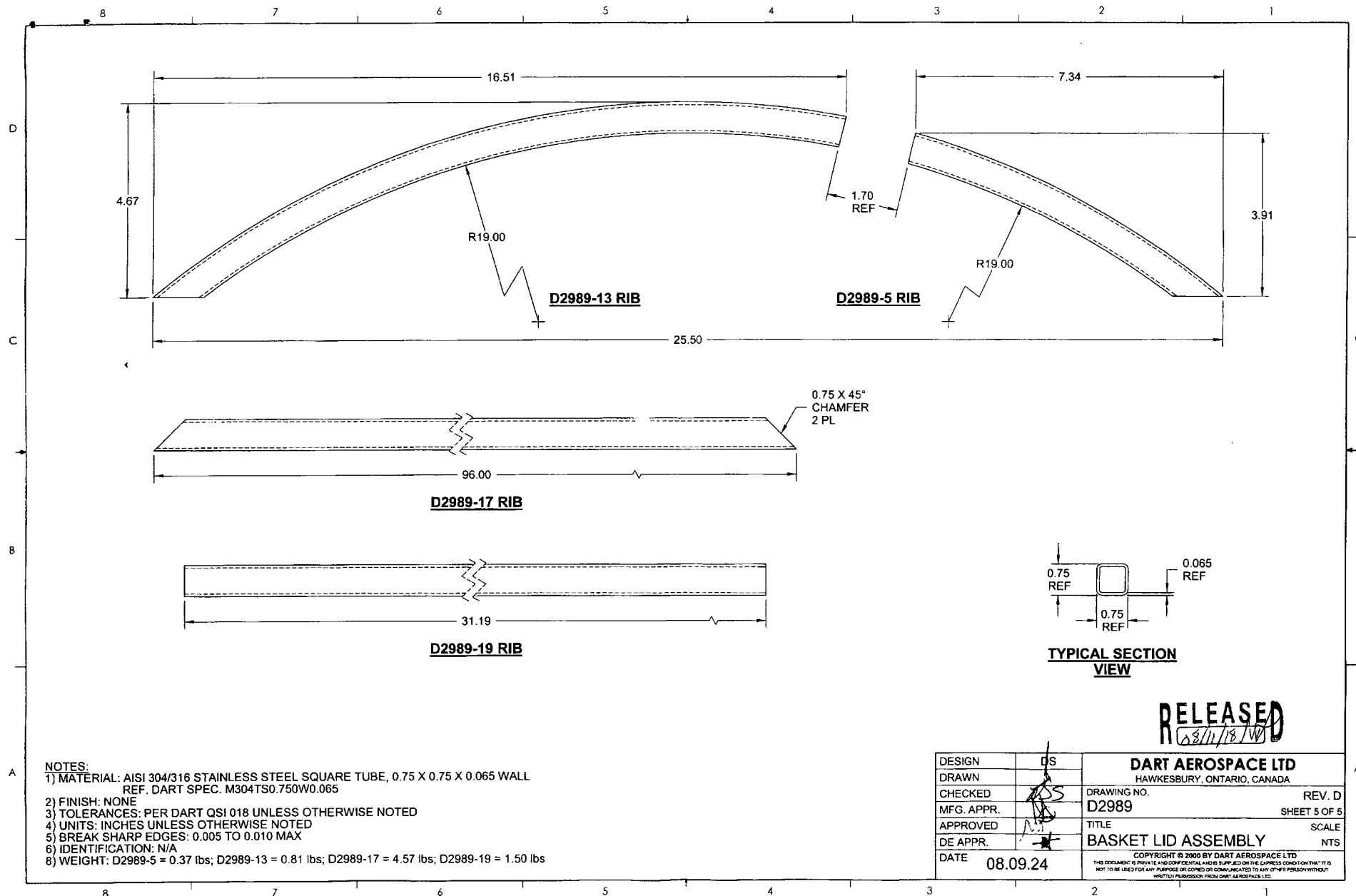
- 1) MATERIAL: D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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DESIGN	DS	DART AEROSPACE LTD	
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CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.		SHEET 5 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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